

Work Order ID 93292

93292

Page 1

November-15-12 10:49:47 AM

Item ID: D3245-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel

Start Date: 11/15/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-12

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3245	D
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100	0.00
-----	------

100	FLOW WATER JET
-------	----------------

Waterjet	Memo	0.00	4	0	JM12-11-21
----------	------	------	---	---	------------

FLOW CNC Waterjet	1-Cut as per Dwg D3245 ****prog.D3245-1/2****
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304 -032	Dwg Rev: 0
----------	------------

Prog Rev: 0

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110	Memo	0.00
-------	------	------

QC		
----	--	--

Quality Control		
-----------------	--	--

4	0	JM12-11-21
---	---	------------

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions		Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Work Order ID 93292

93292

Page 2

November-15-12 10:49:47 AM

Item ID: D3245-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel

Start Date: 11/15/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

QAS
15
9-89

Date:

4

130

130

Brake NC

Brake NC

NC BRAKE

0.00

12/11/12

Date:

SB

12/12/20


12/13/07

Memo

0.00

1- C'sink as per Dwg D3245

2- Form D3245-1 as per Dwg D3245

3- DEBURR

Identify as D3245-1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No.	Rework	Skid-tube	Crosstube	Water Jet	Engineering						
NCR No.	Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality						
	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other						
	Work Order Update	Large Fab	Composite	Supplier							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending	Bend	Grain	Ovalized	Pressure/Forced			
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

Work Order ID 93292

93292

Page 3

November-15-12 10:49:47 AM

Item ID: D3245-2

Accept

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Setup Start

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Start Date: 11/15/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/23/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

5hr
0.00 13/1/08

140

QC

Quality Control

150

Identify as per dwg & Stock Location: 6A

0.00

150

Packaging

Packaging

Memo

0.00

4

BB
13/1/08

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

MUS 13-01-08

WKF
13-01-08

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Picklist Print

November-15-12 10:49:46 AM

Page 1

Work Order ID: 93292

Start Date: 11/15/12

Required Date: 11/23/12

Parent Item: D3245-2

Start Qty: 4.00

Required Qty: 4.00

Parent Item Name: Panel

Comments: IPP A04.07.07New issueKJ/JLM
IPP Rev:b ECN 1052 07-10-31 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	187.9300	0.804	3.3852632 3.4			JM12-11-21

Location	Loc Qty	Loc Code
MAT020	187.93	
118271	8.88	
120866	32.8	
121889	146.25	121889

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

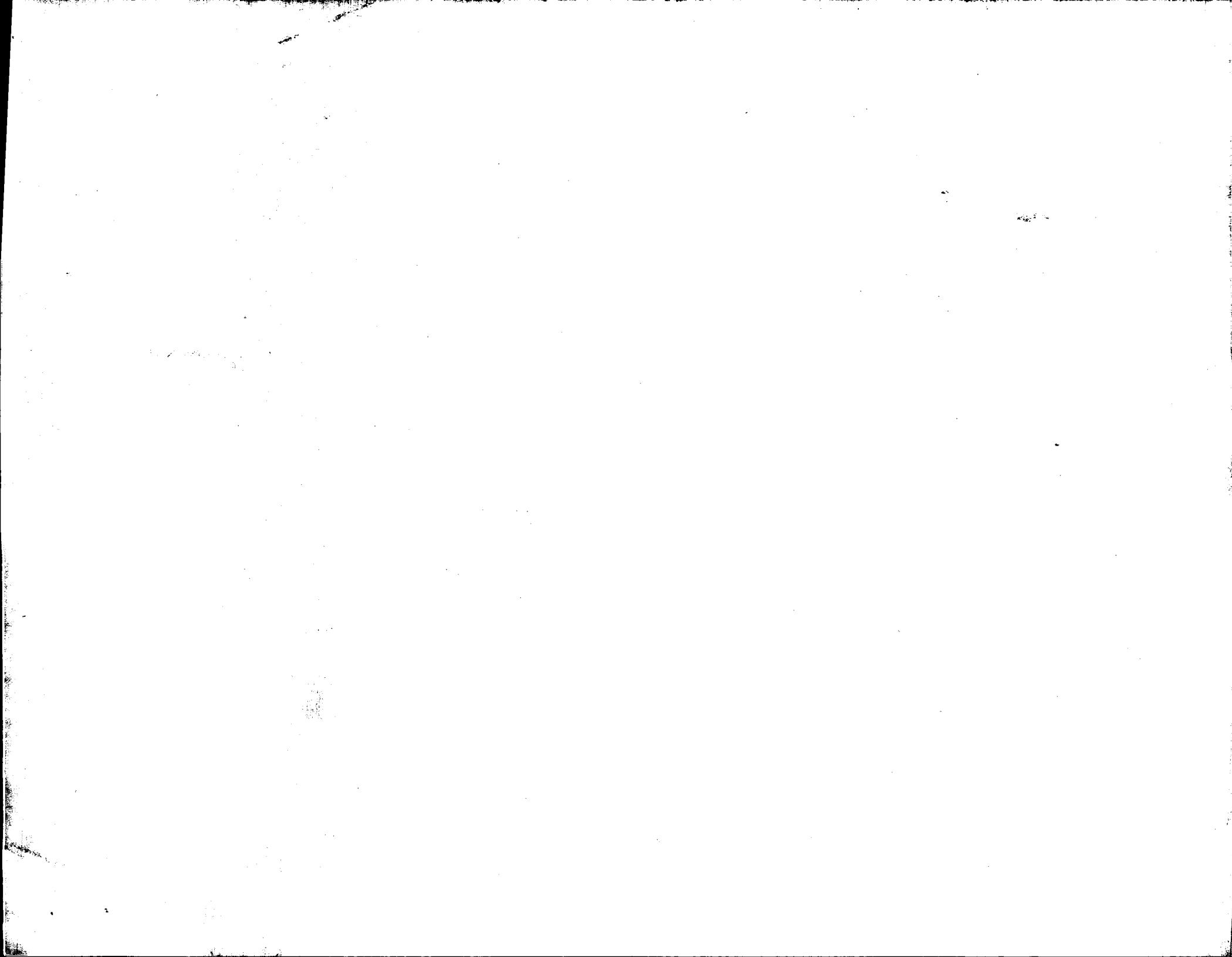
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/>							
				Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							

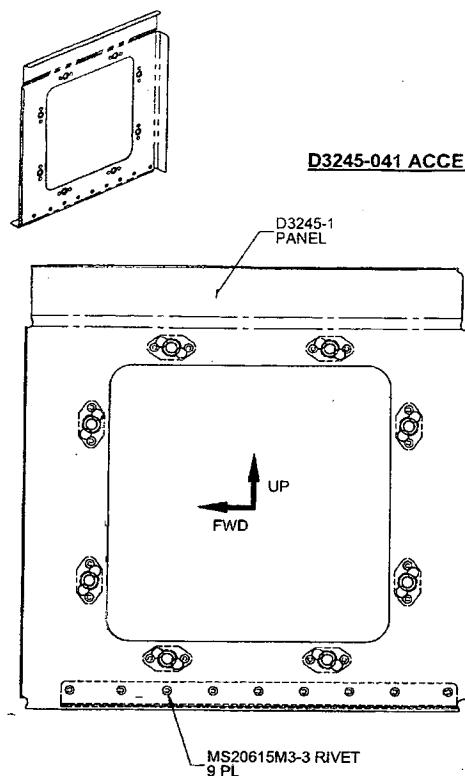
DART AEROSPACE LTD	Work Order:	93292
Description: Panel	Part Number:	D3245-2
Inspection Dwg: D3245	Rev: 6/24	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

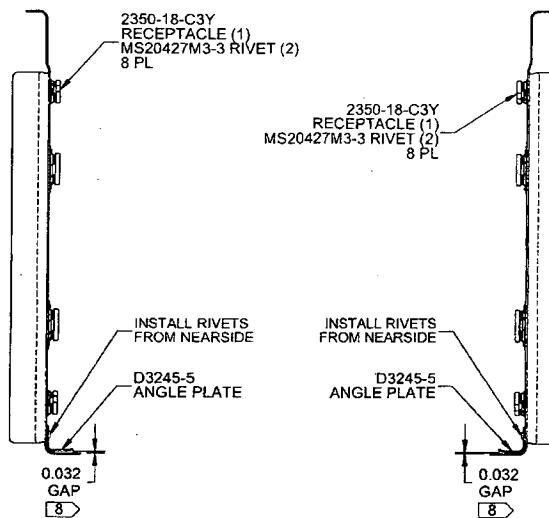
Measured by: <u>Jan</u>	Audited by: <u>DS</u> <u>15</u>	Preliminary Approval:
Date: <u>12-11-21</u>	Date: <u>12-11-21</u>	Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	12.05.14	Dimensions updated per Dwg Rev C	KJ	

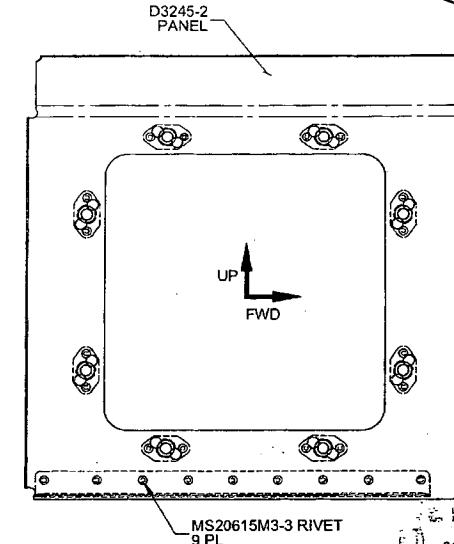




D3245-041 ACCESS PANEL ASSY (LH)



D3245-042 ACCESS PANEL ASSY (RH)



2012-11-06

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTE

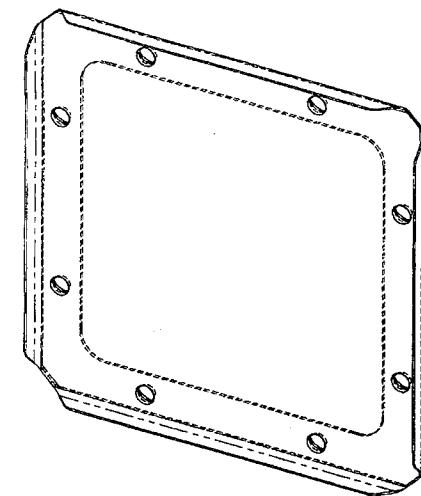
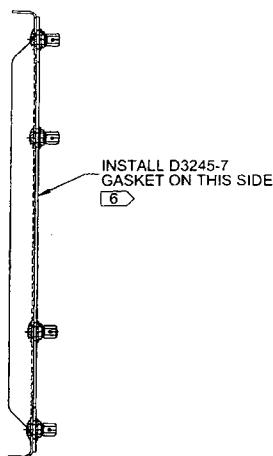
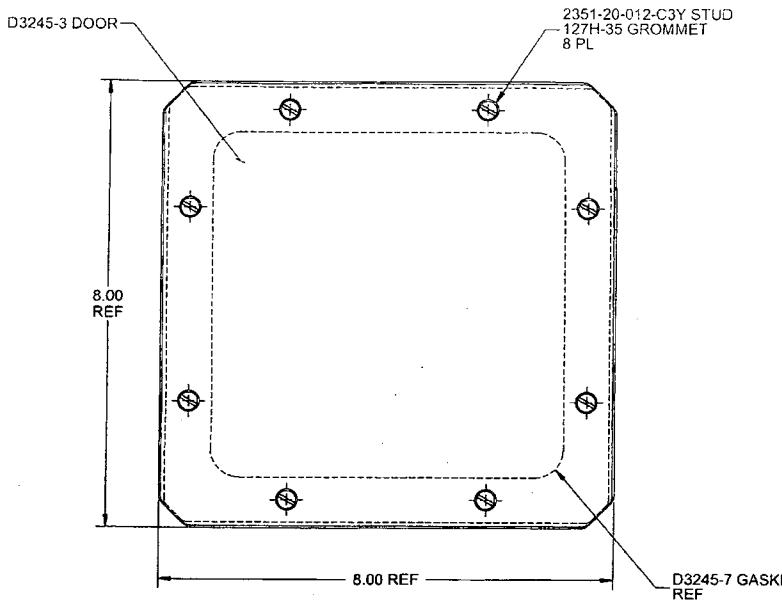
1) MATERIAL: N/A 9 9 MS20615
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.
7) WEIGHT: 0.33 lbs
8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

D	CHANGED MATERIAL FOR D3245-7/9-11/13. REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.16
C	ADDED NOTE 8, SHEET 1. SPECIFIED RIVET ORIENTATION (B6-4) 1/4" RIVET SPAN. 1/4" RIVET SPAN = 22.268- 037 TO 2351-20-012-C3. (D6-4) HOLE SIZE WAS 0.098, 9 PLACES (D6-4). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165.	RP	12.04.11
B	REMOVE Ø.024 HOLES FROM D3245-1/1F, REMOVE MS21060-L3K NUTPLATES & DURABLAck GASKETS FROM D3245-041-042. HOLES AND ITEMS ARE NOW PART OF D3245-041. ASSIGN PINS TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1F</u>	DART AEROSPACE LTD	
DRAWN	<u>13</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>CP</u>	DRAWING NO.	REV. I
MFG. APPR.	<u>1A</u>	D3245	SHEET 1 OF
APPROVED	<u>1A</u>	TITLE	SCALE
DE APPR.	<u>1A</u>	ACCESS PANEL ASSY	
DATE	12.10.16	© COPYRIGHT IS 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND COPIED FOR THE EXPRESS CONSIDERATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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UNCONTROLLED
SUBJECT TO AMENDMENT
WITHHELD BY LAW

93292 ML5
12-11-15

93292



D3245-043 DOOR ASSY

QTY	P/N	DESCRIPTION
1	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD

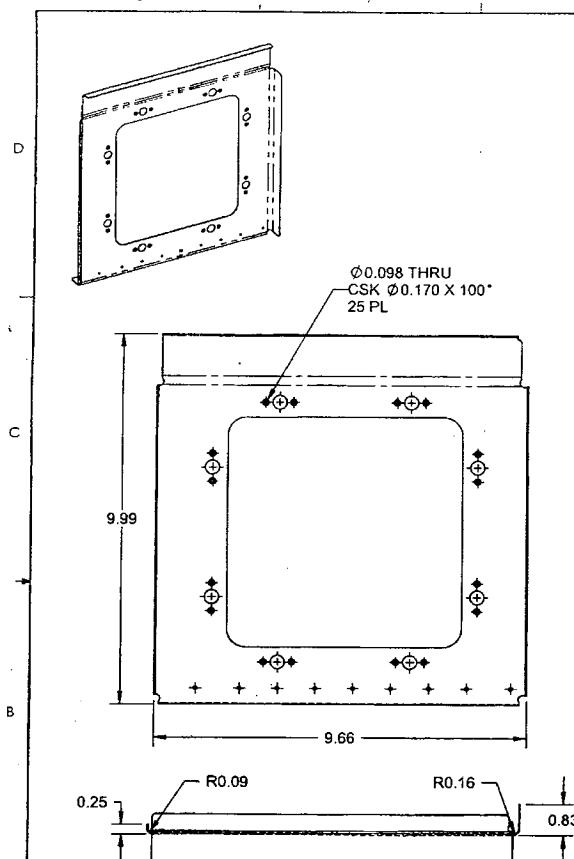
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.74 lbs

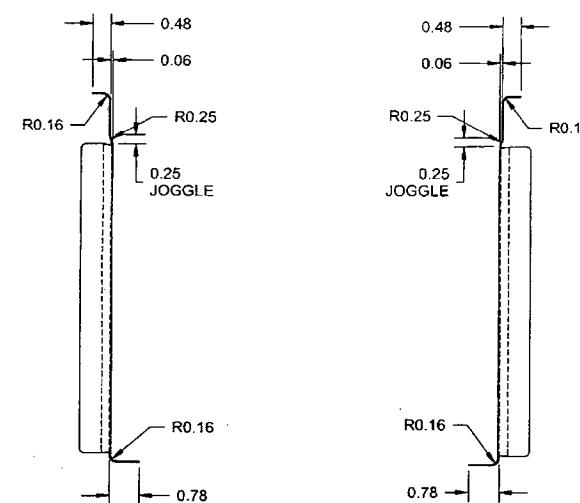
RELEASED
2012-11-06
MJO

DESIGN	<i>PF</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MM</i>	DRAWING NO.	REV. D
MFG. APPR.		D3245	SHEET 2 OF 7
APPROVED	<i>MM</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	ACCESS PANEL ASSY	NTS
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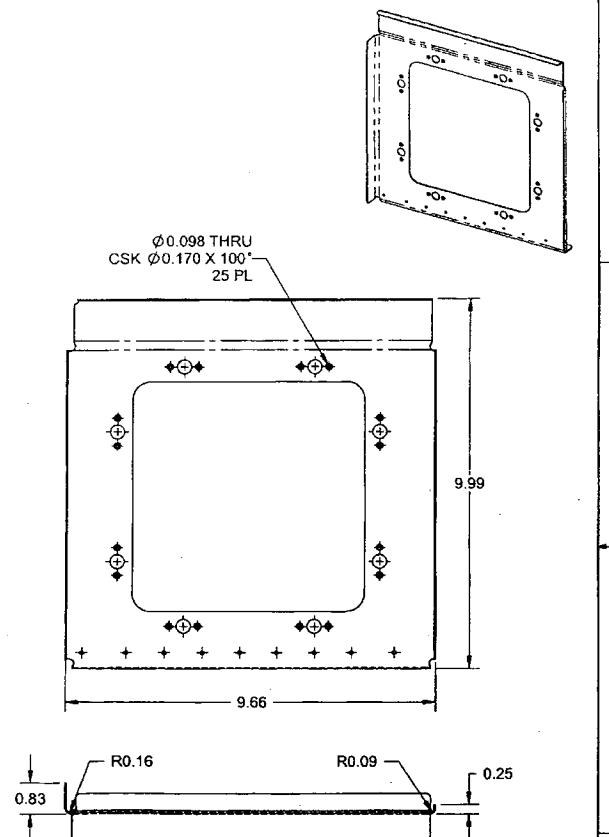
93292



D3245-1 PANEL (LH)



D3245-2 PANEL (RH)



RELEASED
2012-11-06
JW

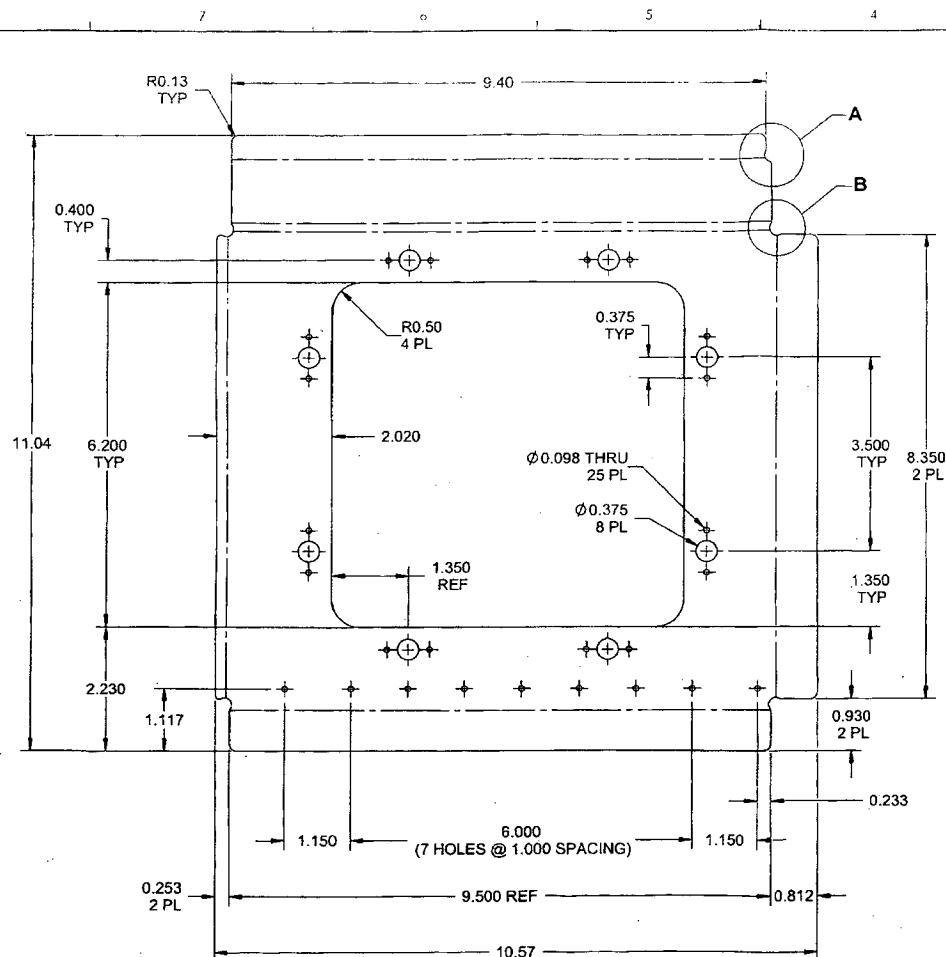
NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.
MFG. APPR.	<input checked="" type="checkbox"/>	REV. D
APPROVED	<input checked="" type="checkbox"/>	D3245 SHEET 3 OF 7
DE APPR.	<input checked="" type="checkbox"/>	TITLE
DATE	12.10.16	SCALE
		NTS

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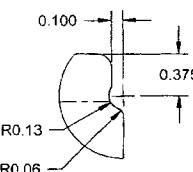
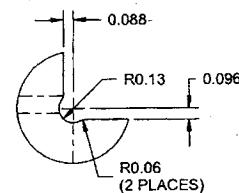
93292



D3245-1F PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

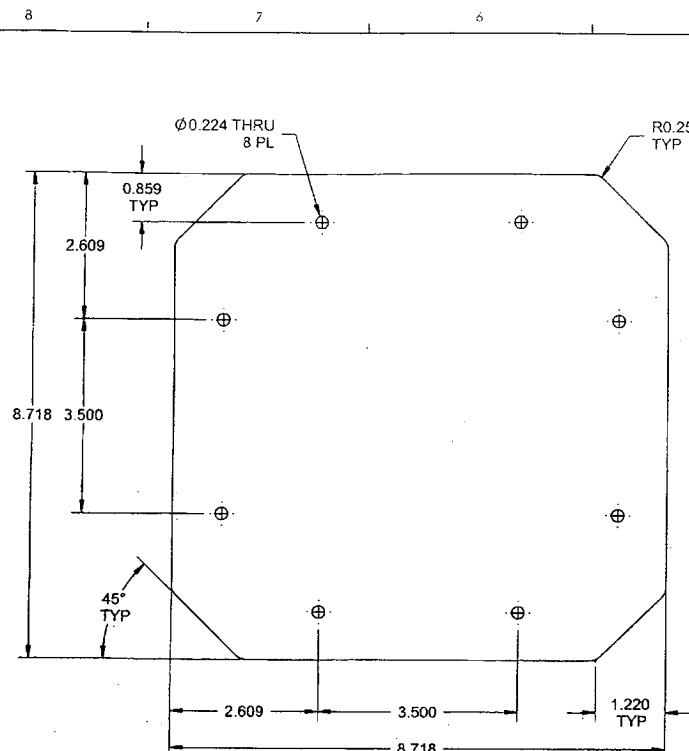
DETAIL A: RELIEF
SCALE 1:1DETAIL B: RELIEF
TYP, 4 PL
SCALE 1:1

RELEASED
2012-11-06

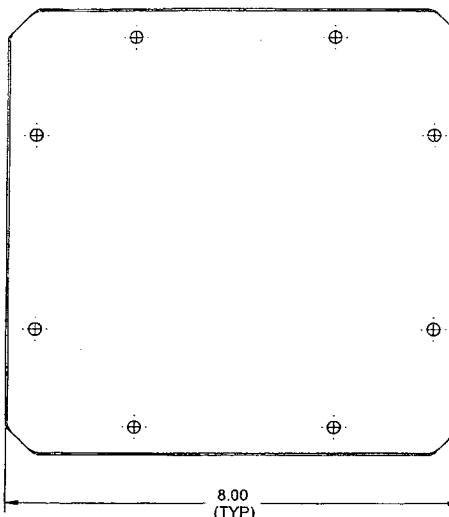
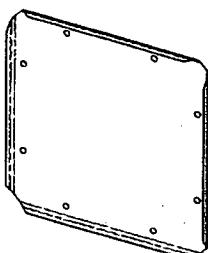
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DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO. REV. D
MFG. APPR.	<input checked="" type="checkbox"/>	D3245 SHEET 4 OF 7
APPROVED	<input checked="" type="checkbox"/>	TITLE
DE APPR.	<input checked="" type="checkbox"/>	SCALE
DATE	12.10.16	ACCESS PANEL ASSY NTS

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93292



D3245-3F DOOR FLAT PATTERN

D3245-3 DOOR
(MADE FROM D3245-3F)

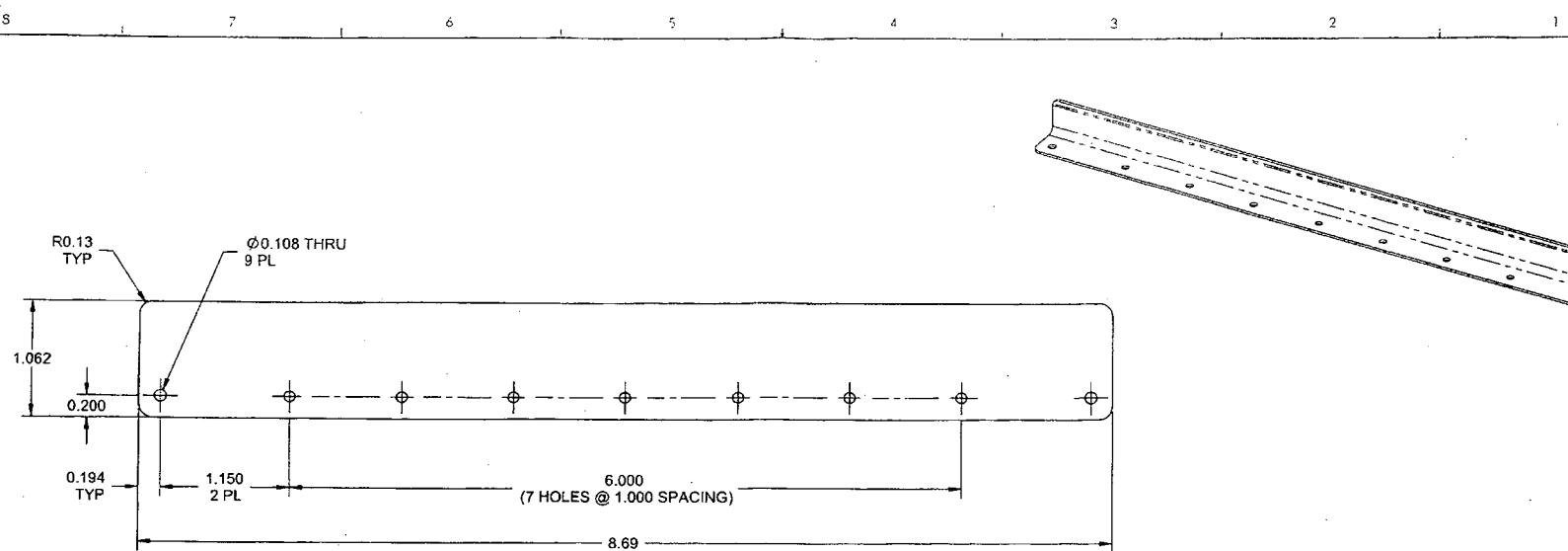
RELEASED
2012-11-06
M

NOTES:

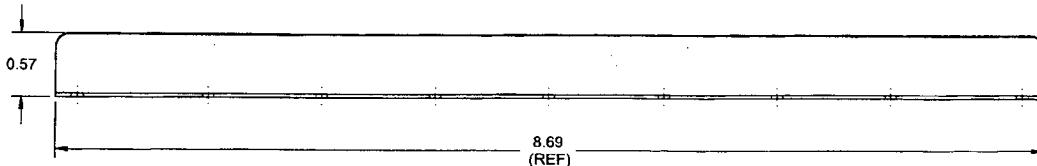
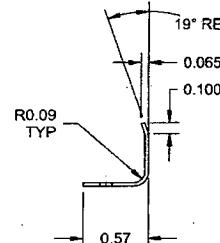
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

DESIGN	PF	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO. REV. D
MFG. APPR.		D3245 SHEET 6 OF 7
APPROVED	W	TITLE SCALE
DE APPR.		ACCESS PANEL ASSY NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

93292



D3245-5F FLAT PATTERN

D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)

RELEASE
2012-11-06
M

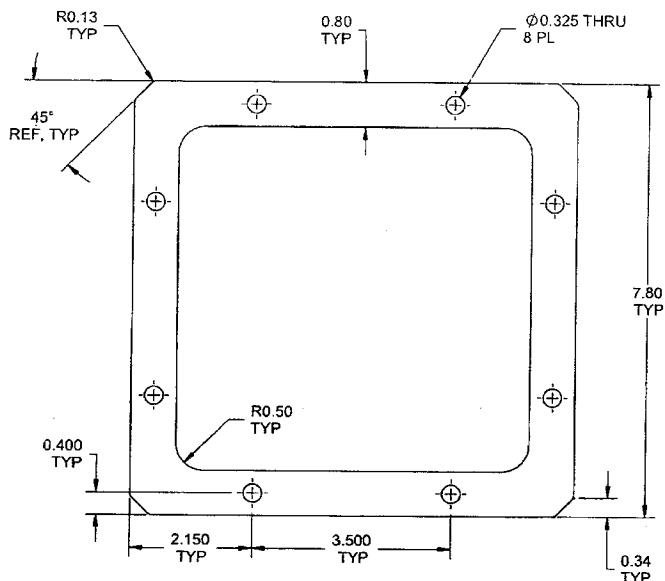
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

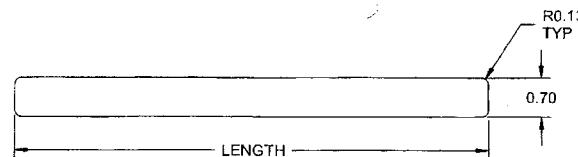
DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.
MFG. APPR.	<input checked="" type="checkbox"/>	D3245
APPROVED	<input checked="" type="checkbox"/>	REV. D
DE APPR.	<input checked="" type="checkbox"/>	SHEET 6 OF 7
DATE	12.10.16	SCALE
		NTS
		ACCESS PANEL ASSY

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93292



D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP 
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. D
APPROVED		D3245
DE APPR.		SHEET 7 OF 7
DATE 12.10.16		SCALE NTS
TITLE ACCESS PANEL ASSY		

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2012-11-06
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